












Date: Friday, 24/10/2008 3:32:12 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: TUBE
<b>Job Number</b>	: 42961		
<b>Estimate Number</b>	: 13373		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D37693
<b>This Issue</b>	: 24/10/2008 <b>S.O. No.</b> :	<b>Drawing Number</b>	: D3769 REVA
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b>	: A
<b>Previous Run</b>	: 40976	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 03/11/2008 <b>Qty:</b> 22 <b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: <u>JLD 08-10-24</u>		
<b>Comment</b>	: Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC Est Rev:B 08-08-27 Drilling Tooling Added JLM Verified By:EC		
<b>Additional Product</b>			
Job Number: 			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w	
			
<b>Comment:</b> Qty.: 1.3283 f(s)/Unit Total : 29.2215 f(s) 6061T6 TUBE (1.00" x 0.65" wall) batch: <u>M109760</u> <u>M-L 09/01/06</u>			
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1  1-cut tube to lenght as per dwg D3769  2-drill holes thru on both ends of tube as per dwg D3769 using DT9411 Jig 3- deburr <u>M-L 09/01/07</u>			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
			
<b>Comment:</b> INSPECT WORK TO CURRENT STEP <u>S 09/01/07</u> <u>counter</u> <u>(22)</u>			
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
<b>Comment:</b> HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>FL 09/01/08</u> <u>(22)</u>			
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
			
<b>Comment:</b> INSPECT POWDER COAT/CHEMICAL CONVERSION <u>09-08-08</u> <u>(22)</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 42961

Part Number: D37693

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST250

JS 09/01/08 x20

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/12 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

C

B

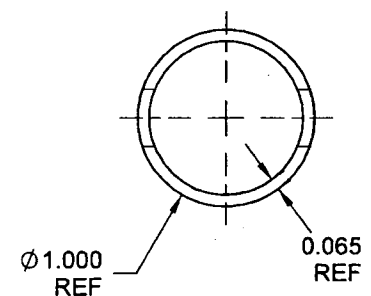
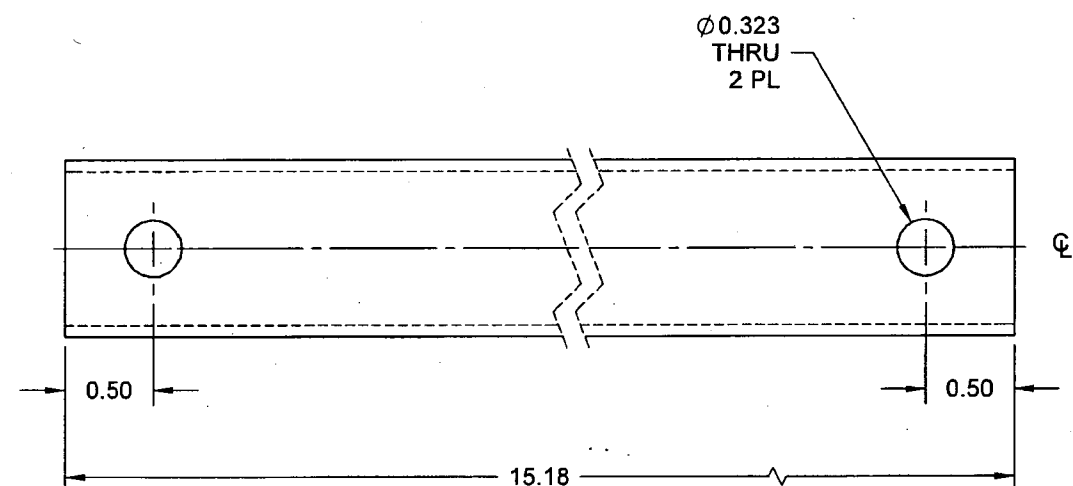
B

D3769-1 TUBED3769-3 TUBED3769-5 TUBE**RELEASED**  
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WORK ORDER  
NO. 42961**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3769-1, 0.27 lbs  
D3769-3, 0.28 lbs  
D3769-5, 0.37 lbs

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5305



D3769-3 TUBE

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